

5/45 2434

DART AEROSPACE LTD.	Work Order:	24434
Description: Saddle Fitting, Aft (Outboard/Inboard).	Part Number:	D2573/D2574
Drawing: D2573 Rev. D/D2574 Rev. D	Qty:	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	MS	05.10.12	8
2	MV	Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No. B24893	MS	06/01/12	
3	MV	Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B21801	MS	06/01/12	8
4	MV	Fixturing W/O No. _____ Fixturing Inspection last completed _____ by _____		N/A	
5	MV	Program Batch No. <u>B24434</u> Double check by: <u>MS</u>	MS	06/01/12	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	J.G. MS	06/01/12	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	J.G. MS	06/01/12	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	J.G. MS	06/01/12	8
9	MV	Machine keyway as per dwg D2573 & D2574	J.G. MS	06/01/16	8
10	MV	Deburr and remove all machining marks	J.G.	06/01/16	8
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	N/A J.G.	06/01/20	8
12	QC1	Inspect all dimensions to dimension sheets	J.G.	06/01/19	8
13	QC7	Second inspection	RG	06.01.20	8
14	FP	Acid etch and alodine as per QSI 005 4.1	SAD	06.01.21	8
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	MS	06 01 31	8
16	QC3	Inspect Powder Coat	CL	06/01/31	8
17	ST	Identify and Stock.	CL	06/01/31	8
18	AC	Cost / Part	Suc	06-02-01	8
19	DC	Close W/O Inspection Level 21	MS	06/02/11	8

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ RF	

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/02/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24434
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.446		
B	1.745	1.755		1.748	1.746	1.748	1.748		
C	3.495	3.505		3.498	3.498	3.499	3.497		
D	1.745	1.755		1.750	1.748	1.750	1.746		
E	7.990	8.010		8.003	8.003	8.004	8.004		
F	0.490	0.510		0.500	0.499	0.498	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.499	0.498	0.499		
J	1.174	1.184		1.177	1.176	1.177	1.177		
K	0.558	0.578		0.568	0.564	0.562	0.564		
L	1.174	1.184		1.177	1.176	1.176	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.497	2.497	2.496	2.496		
O	4.119	4.129		4.120	4.119	4.119	4.120		
P	0.115	0.135		0.124	0.123	0.123	0.123		
Q	0.115	0.135		0.130	0.130	0.129	0.128		
R	0.240	0.260		0.245	0.246	0.246	0.247		
S	0.115	0.135		0.118	0.118	0.118	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.231	3.231		
V	0.230	0.250		0.233	0.234	0.233	0.234		
W	0.115	0.135		0.121	0.122	0.121	0.122		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.367	0.366	0.362	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.253	0.250	0.249		
AE	1.500	1.520		1.515	1.513	1.514	1.510		
AF	0.115	0.135		0.130	0.131	0.132	0.133		
AG	0.240	0.280		0.262	0.261	0.260	0.262		
AH	0.240	0.260		0.246	0.245	0.245	0.244		
AI	2.000	2.020		2.000	2.000	2.002	2.001		
Accept/Reject									

Measured by:	B.G.
Date:	06/01/14

Audited by:	EP
Date:	06/01/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED
05.05.05

DART AEROSPACE LTD	Work Order: 24434
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.746	1.746	1.746		
C	3.495	3.505		3.497	3.496	3.496	3.496		
D	1.745	1.755		1.748	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.495	0.499	0.498	0.499		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.501	0.500	0.501		
J	1.174	1.184		1.176	1.176	1.176	1.176		
K	0.558	0.578		0.566	0.566	0.566	0.565		
L	1.174	1.184		1.175	1.175	1.176	1.176		
M	1.365	1.375		1.367	1.368	1.367	1.367		
N	2.495	2.505		2.497	2.497	2.496	2.497		
O	4.119	4.129		4.120	4.119	4.119	4.120		
P	0.115	0.135		0.125	0.124	0.125	0.126		
Q	0.115	0.135		0.135	0.133	0.133	0.135		
R	0.240	0.260		0.248	0.247	0.246	0.247		
S	0.115	0.135		0.118	0.116	0.117	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.230	3.231	3.230		
V	0.230	0.250		0.233	0.234	0.235	0.233		
W	0.115	0.135		0.123	0.123	0.124	0.125		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.362	0.361	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.628	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.248	0.248		
AE	1.500	1.520		1.516	1.515	1.515	1.516		
AF	0.115	0.135		0.132	0.133	0.134	0.132		
AG	0.240	0.280		0.265	0.264	0.260	0.261		
AH	0.240	0.260		0.242	0.242	0.243	0.242		
AI	2.000	2.020		2.003	2.003	2.002	2.001		
Accept/Reject									

Measured by: J.G.
Date: 06/01/16

Audited by: Eo
Date: 06/01/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED
05.05.05

DART AEROSPACE LTD		Work Order:	24434
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.747	1.748		
C	3.495	3.505		3.498	3.496	3.496	3.497		
D	1.745	1.755		1.750	1.748	1.748	1.748		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.497	0.498	0.497	0.497		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.498	0.500	0.498		
J	1.174	1.184		1.176	1.176	1.176	1.177		
K	0.558	0.578		0.569	0.567	0.566	0.567		
L	1.174	1.184		1.176	1.176	1.176	1.176		
M	1.365	1.375		1.368	1.367	1.368	1.367		
N	2.495	2.505		2.496	2.496	2.496	2.496		
O	4.119	4.129		4.120	4.119	4.119	4.120		
P	0.115	0.135		0.123	0.123	0.127	0.127		
Q	0.115	0.135		0.132	0.133	0.131	0.133		
R	0.240	0.260		0.246	0.245	0.247	0.248		
S	0.115	0.135		0.124	0.123	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.231	3.231	3.232		
V	0.230	0.250		0.235	0.234	0.237	0.236		
W	0.115	0.135		0.125	0.124	0.124	0.125		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.356	0.357	0.359	0.355		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.625	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.250	0.247		
AE	1.500	1.520		1.512	1.515	1.511	1.510		
AF	0.115	0.135		0.130	0.131	0.132	0.133		
AG	0.240	0.280		0.262	0.261	0.263	0.262		
AH	0.240	0.260		0.246	0.245	0.244	0.243		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
Accept/Reject									

Measured by:	3.6
Date:	06/01/15

Audited by:	EP
Date:	06/01/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	

RELEASED
#05.05.05

DART AEROSPACE LTD		Work Order:	24434
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.746	1.746		
C	3.495	3.505		3.496	3.497	3.497	3.496		
D	1.745	1.755		1.746	1.746	1.747	1.747		
E	7.990	8.010		8.004	8.004	8.003	8.005		
F	0.490	0.510		0.499	0.498	0.500	0.501		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.499	0.501	0.501		
J	1.174	1.184		1.176	1.176	1.177	1.177		
K	0.558	0.578		0.564	0.567	0.566	0.566		
L	1.174	1.184		1.176	1.176	1.176	1.177		
M	1.365	1.375		1.368	1.367	1.368	1.367		
N	2.495	2.505		2.497	2.496	2.497	2.496		
O	4.119	4.129		4.119	4.120	4.120	4.120		
P	0.115	0.135		0.123	0.124	0.123	0.123		
Q	0.115	0.135		0.127	0.128	0.127	0.128		
R	0.240	0.260		0.244	0.244	0.247	0.245		
S	0.115	0.135		0.124	0.123	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.231	3.230	3.231		
V	0.230	0.250		0.235	0.234	0.233	0.232		
W	0.115	0.135		0.124	0.125	0.123	0.122		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.358	0.359	0.357		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.628	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.251	0.250	0.249		
AE	1.500	1.520		1.515	1.512	1.513	1.513		
AF	0.115	0.135		0.129	0.128	0.127	0.128		
AG	0.240	0.280		0.264	0.263	0.264	0.264		
AH	0.240	0.260		0.250	0.247	0.247	0.246		
AI	2.000	2.020		2.001	2.001	2.002	2.001		
Accept/Reject									

Measured by:	J.G.
Date:	06/01/16

Audited by:	En
Date:	06/01/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	#

RELEASED
#05.05.05

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 05, 2005
10:49 am

Work Order No : 0024434S
Project Name : D2574
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D2574
Description : Saddle, Aft, In
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 10-05-05
Est Finish Date : 11-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 05, 2005
10:49 am

Work Order No : 0024434
Project Name : D2573/74
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2573
Description : Saddle, Aft, Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 10-05-05
Est Finish Date : 11-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:09 pm

Work Order No : 0024434
Project Name : D2573/74
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2573
Description : Saddle, Aft, Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 10-05-05
Est Finish Date : 11-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

MIS 2/13
w
11-15

Date: Monday, 14/11/2005 3:41:21 PM
User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)	
Job Number :	24434			
Estimate Number :	10533			
P.O. Number :		Part Number :	D2573	
This Issue :	14/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D2573 REV D	
First Issue :	//	Project Number :		
Previous Run :		Drawing Revision :	D	
	Type :	Material :		
	MACHINED PARTS	Due Date :	30/11/2005	Qty: 8 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. _____ Double check by: _____

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Date:
User:

Monday, 14/11/2005 3:41:21 PM
Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24434

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

